

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004129**Date Inspected:** 30-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:****Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:****Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:****Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:****Yes No N/A****Delayed / Cancelled:****Yes No N/A****Bridge No:** 34-0006**Component:** OBG Deck Panel**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Deck Panel	NA	NA	QAUT

OBG

Assembly Building: Caltrans Quality Assurance (QA) inspector received notification from 2nd shift Task Leader to perform conventional ultrasonic test (UT), gate to gate inspection of tack welds joining u-rib to deck plate. The deck panels are identified as DP353-001 and DP299-001. The UT inspection performed by the Caltrans QA inspector was preliminary UT inspection prior to using the phased array UT system to verify indications found by the conventional ultrasonic test. Caltrans QA inspector inspected deck panel DP353-001, welds 006, 007, 008, 009, 010 and DP299-001, welds 004, 005 and 006. Each weld consisted of eighteen (18) tack welds. Caltrans QA inspector recorded Y-locations for indications found in the weld during the UT inspection for the following:

Deck Panel DP353-001

Weld 006; No indications observed.

Weld 007; Observed weld indication at Y-location, 6640 millimeter mark.

Weld 008; Observed weld indication at Y-location, 4830, 6040, 7830, 9220 millimeter mark.

Weld 009; Observed weld indications at Y-location, 3095, 3670, 4230, 4835, 4855, 4890, 5455, 5485, 6030, 6045, 6080, 6100, 6695, 7250, 7840, 7900, 8490 and 8900 millimeter mark.

Weld 010; Observed weld indication a Y-location, 4840, 8900 and 9280 millimeter mark. The following digital

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pictures illustrate DP353-001 deck panel and weld 009 Y-location markings.



2	Deck Panel	NA	NA	QAUT
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Deck Panel DP299-001

Weld 004; Observed weld indication at Y-location, 2025, 2685, 3125 and 3295 millimeter mark.

Weld 005; Observed weld indication at Y-location, 3265, 3825, 4510, 6320, 7515, 7610 and 8705 millimeter mark.

Weld 006; Observed weld indication at Y-location, 2085, 2695, 3865, 5630 and 7620 millimeter mark.

Caltrans QA inspector was informed by the task leader that a TL-6027 was not required at this time.

Welds 001, 002, 003, 004, 005 and 006 for DP353-001 and DP299-001, welds 001, 002, 003 were inspected by Caltrans QA inspector, Mr. Erik Prue. See Caltrans U-rib to Deck Panel-Tack Weld Assessment Record, dated 09-30-2008 for additional information.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler,Mike	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
